ASAP

Dart Aerospace Ltd.

Date: Tuesday, 8/21/2007 3:44:01 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 34196B		
Estimate Number	: 10395		
P.O. Number	: N/A	Part Number	: D29685
This Issue	: 8/21/2007 S.O. No. : N/A	Drawing Number	: D2968
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: ~~B1~~ C
Previous Run	: 33362B	Material	: N/A
Written By	:	Due Date	: 9/20/2007 Qty: 20 Um: Each
Checked & Approved By	: 07.08.22		
Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF		

CE 07.08.23

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT3000W500	4130 Tube 3"ODx.5"W

Comment: Qty.: 0.0587 f(s)/Unit Total : 1.1739 f(s)
Material: AISI 4130 Ø 3.00 .500" WALL " Bar
(M4130N-R0.750) Batch: M103452
Identify AS D2968-1
J.L 07/10/05 (20)

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI LATHE
1-Turn Blank as per Folio FA049 and Dwg D2968
2-Deburr, no sharp edges
J.L 07/10/05 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE
J.L 07/10/05 (20)

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK
07/10/05 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____
07/10/09 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** LD **Date:** 07/10/09

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:44:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** RING

Job Number: 34196B **Part Number:** D29685

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

CL07/10/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34196B
Description: Tow Ring	Part Number:	D2968-5
Inspection Dwg: D2968 **Rev:** ~~B~~ C		Page 1 of 1

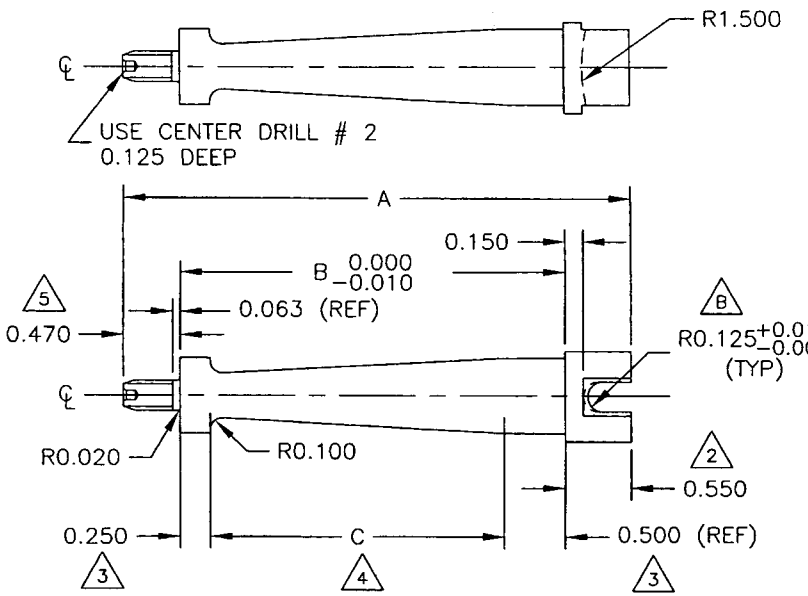
FIRST ARTICLE INSPECTION CHECKLIST

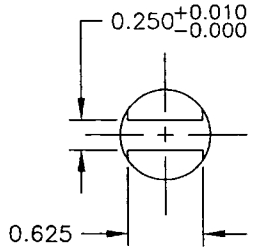
[X] First Article [ ] Prototype

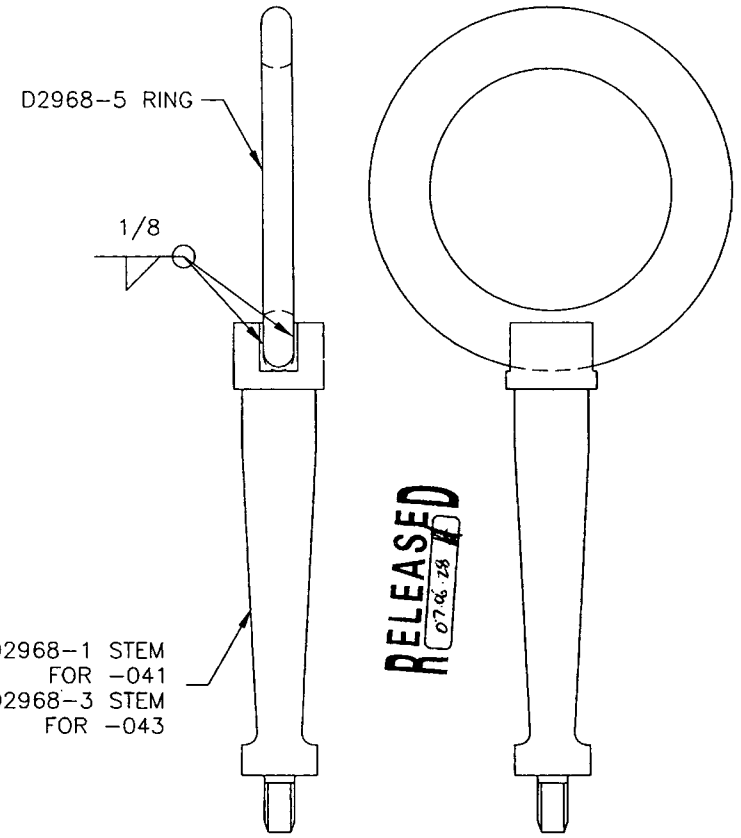
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.000	+/-0.010	2.990	✓			
Ø2.050	+/-0.010	2.050	✓			
0.250	+/-0.010	.260	✓			
R0.125	+0.000/-0.010	R.125	✓			

Measured by:	J.L	Audited by:		Prototype Approval:	N/A
Date:	07/10/05	Date:	07/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D2968-041/-043	KJ/RF	







RELEASED 07.06.28

PART NUMBER	A	B	C
D2968−1	5.040	4.020	3.270
D2968−3	4.200	3.180	2.430

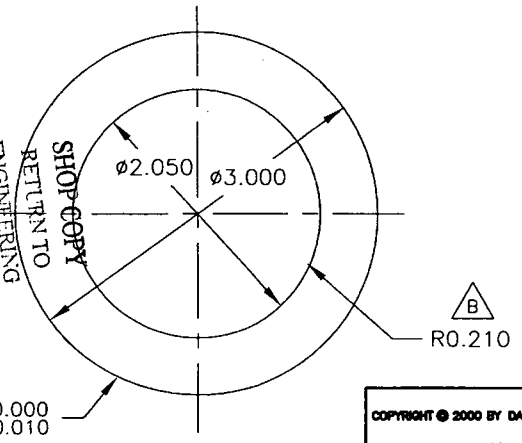
D2968−1/−3 STEM

D2968−1 AND D2968−3 STEM:

1) MATERIAL: AISI 4130N ROUND BAR PER MIL−S−6758 OR AMS 6348/6370/6528 (REF DART SPEC M4130N−RX.XXX)
2) ø0.750 O.D.
3) ø0.625 O.D.
4) MACHINE UNIFORM TAPER FROM ø0.363 O.D. TO ø0.625 O.D.
5) 1/4−28 UNF THREAD WITH 0.063 GRIP
6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED
7) ALL DIMENSIONS ARE IN INCHES
8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968−5 RING:

9) MATERIAL: AISI 4130N TUBING PER MIL−T−6736 OR AMS 6360/6361/6362/6371/6373/6374 (REF DART SPEC M4130NT3000W500)
10) ALL DIMENSIONS ARE IN INCHES
11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968−5 RING

D2968−041 AND D2968−043 TOW RING:

12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER QQ−P−416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2968	REV. C SHEET 1 OF 1
DATE 07.04.17		TITLE TOW RING	SCALE 1:1